Monday, 18/09/2006 9:05:19 AM

User:

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 28481

Estimate Number

: 10827

P.O. Number This Issue

: N/A

: 18/09/2006

S.O. No. : N/A

Prsht Rev. First Issue

Previous Run

: 28481

Type

: SMALL /MED FAB

Project Number Drawing Revision

Drawing Number

Drawing Name

Part Number

Material **Due Date** :NA

: D2877

: N/A

: B

: 25/09/2006

D2877 REV B

: SADDLE SPACER

Qty:

Each 120 Um:

Written By

Checked & Approved By

Comment

В : Est Est С

19 Added inspect level 8 EC 06,04.26 Water jet EC

Now M6061-T6

06-06-23 JLM

Est Rev:D Est Rev:E

Updated Thickness as per Rev B 06-09-18 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S125

6061-T6 .125 Sheet



Comment: Qty.:

0.5468 sf(s)/Unit Total:

65.6208 sf(s)

Material: 6061-T6 (QQ-A-250/8) 0.125" Thick

Batch: M101092

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2877

Dwg Rev: 13

Prog Rev:

2- Tumble

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

Comment: SECOND CHECK

SECOND CHECK





Date: Monday, 18/09/2006 9:05:19 AM Linda Lacelle User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SADDLE SPACER Job Number: 28481 Part Number: D2877 Job Number: Seq. #: **Machine Or Operation:** Description: SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling 540 0610:02 HAND FINISHING RESOURCE #1 6.0 counted Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE # 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE N Valo. 26 Job Completion

, Date:

Monday, 9/11/2006 3:43:50 PM

Kim Johnston User: **Process Sheet Drawing Name** : SADDLE SPACER : CU-DAR001 Dart Helicopters Services Customer Job Number : 28481 **Estimate Number** : 10827 **Part Number** : D2877 P.O. Number **Drawing Number** : D2877 REV B : 9/11/2006 S.O. No. : This Issue : N/A : NC **Project Number** Prsht Rev. : SMALL /MED FAB : // Type **Drawing Revision** First Issue : NOTE:1 BLANK MAKES 4 PARTS : 26513 Material **Previous Run** 120 Um: Each **Due Date** : 9/22/2006 Qty: Written By Checked & Approved By 00.05.19 Added inspect level 8 EC : Est В Comment С 06.04.26 Water jet EC Est 06-06-23 JLM Now M6061-T6 Est Rev:D **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 6061-T6 .100 Sheet M6061T6S100 1.0 0.5468 sf(s)/Unit Total: 6,6208 sf(s) Material: 6061-T6 (QQ A-250/8) 0.100" Thick Batch: FLOW WATER JET WATER JET 2.0 **Comment: FLOW WATER JET** 1-Cut as per Dwg D2877 Dwg Rev:_ Prog Rev:___ 2- Tumble INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 Comment: SECOND CHECK SMALL & MEDIUM FAB RESQURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble

Page 1

Deburr any rough edges after tumbling

Form: rorocess...

Dart Ae	rospace	Lta							
W/O:			WO	RK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	Date: _	
					QA: I	N/C Close	d:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCI	₹)	-		
		Description of NC	Corrective Action Section		tion B Vorif		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Sect.	Verification Section C	Chief Eng	QC Inspector
·									
: [

NOTE: Date & initial all entries

Däte:*

Monday, 9/11/2006 3:43:50 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 28481

Part Number: D2877

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:_____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANG	SES					
DATE	STEP	PROCEDURE CHANGE				, I	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							 			
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:					· · · · · · · · · · · · · · · · · · ·
·							Closed	d:	Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval	
DATE		Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28481
Description: Saddle Spacer	Part Number:	D2877
Inspection Dwg: D2877 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	
0.98	+/-0.030	0.994			VerN	
R0.06	+/-0.030	RO.06	/		RACIUS GU	asl
R0.30	+/-0.030	R0.30	$\sqrt{}$		RAVIVS GU	inge
1.00	+/-0.030	1.013	V		VerN	<i>d</i>
0.250	+0.030/-0.000	0.250	/		vern	
Ø0.257	+0.005/-0.000	0257	/		VerN	
-0.100 thick	+/-0.005	0.121	/		Yern	
0,125"						
				-		
						

	/ / /				
Measured by:		Audited by:	4	Prototype Approval:	N/A
Date:	09.18	Date:	06.05.26	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.01.21	New Issue	KJ/RF	1
В	06.06.23	Dwg Rev. changed	KJ/JLM	
			7 ()	//



DESIG	" AP	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	(ED	APPROVED A	DRAWING NO. REV. B
	PH	-#	D2877 SHEET 1 OF 1
DATE			TITLE SCALE
06.0	5.17		SADDLE SPACER 1:1
Α		99.02.23	NEW ISSUE
В		06.05.17	THICKNESS WAS 0.100", MAT CHANGE

RELEASED

242=2876 RO.44 (TYP 2 PLACES) 0.98 -R0.06 (TYP. 4 PLACES) Ø0.257 (TYP) 3.36 2.358 R0.30 R0.88 -(TYP) 1.00 1.179 R0.40 (TYP) 0.555 -0.542 -0.250±0.000 (TYP) 1.370 · 2.36 -SHOP COPY NOTES: RETURN TO

1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK

(REF DART SPEC M6061T6S.125)

5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK SUBJECT TO AMENDMENT (REF DART SPEC M5052H32S.125)

ENGINEERING

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

ALL DIMENSIONS ARE IN INCHES

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